

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019736**Date Inspected:** 17-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Bay 14:

Notification no: 008203.

OBG Seg 13CW:

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated MT report for this date. The members are identified as OBG components. The weld designations MT inspected are as follows:

- 1) FB3220-001- 122 to 125, 130 to 133, 139, 140, 145, 146, 148, 149.
- 2) SEG3015K- 022, 023.

Notification no: 008201.

OBG Seg 13CW:

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This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC QC personnel. This QA Inspector has generated MT report for this date. The members are identified as OBG components. The weld designations MT inspected are as follows:

- 1) SEG3015N- 044 to 056.
- 2) LD3036-001-201~204, 230, 231, 257, 258, 287, 288, 317, 318.

This QA Inspector observed the following work in progress:

OBG Seg 13CW

The Submerged Arc Welding (SAW) process on weld joint no: SEG3015-001 [Deck Panel (DP) 3148A to DP3149A, complete joint penetration (CJP) weld]. The welder is identified as 250050 and was observed welding in the 1G position. ZPMC QC was identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with WPS: B-T-223(2)1T-ESAB-1.

OBG Seg 13AW:

Repair welding of weld joint no: SEG3013P-275 [Edge Beam (EB) 3045B to Floor Beam (FB) 3176A, CJP weld at panel point (PP) 118]. The welder is identified as 067183 and was observed welding in the 4G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC QC was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair. Repair welding was done as per Welding Repair Report (WRR): B-WR 19920 Rev-0.

Repair welding of weld joint no: SEG3013AK-124 (EB3049A to FB3184A, CJP weld at PP119). The welder is identified as 066236 and was observed welding in the 2G position. Welding process was identified as Flux Cored Arc Welding (FCAW). ZPMC QC was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with WPS: 345-FCAW-2G(2F)-FCM-Repair. Repair welding was done as per WRR: B-WR 19913 Rev-0.

OBG Seg 14W:

Repair welding of weld joint no: SEG3020X-008 [FB3327A to Longitudinal Diaphragm (LD) 3051A, CJP weld at PP127]. The welder is identified as 051348 and was observed welding in the 3G position. Welding process was identified as SMAW. ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-3G(3F)-FCM-Repair. Repair welding was done as per WRR: B-WR 20152 Rev-0.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No significant conversations were reported on this date.

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By:	Wadkar,Sailesh	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
